

Work Order ID 98586

March-14-13 1:14:04 PM

98586

PRELIMINARY ISSUE

Page 1

Item ID: D4785-3

Revision ID: PRELIM

Item Name: Rib

Start Date: 3/14/13 Start Qty: 1.00

Required Date: 3/28/13 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: MLJ Date: 13-03-14 Tooling:

QC: Date: SPC (Y/N):

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4785 | PA2 |

100

0.00

100

Large Fab

Large Fab

Memo

1- Cut tube as per dwg D4785
2- remove identification marks and deburr

0.00

QC 13.3.18

1x

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Quality Control

Memo

0.00

QC 13.3.19

1

120

Identify as per dwg & Stock Location: WA 4

0.00

120

Packaging

Packaging

Memo

0.00

QC 13.3.18

1x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
|---|---|---|

| | |
|--|---|
| <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|---|

Work Order ID 98586

March-14-13 1:14:04 PM

98586

Page 2

Item ID: D4785-3

Revision ID: PRELIM

Item Name: Rib

Start Date: 3/14/13 Start Qty: 1.00

Required Date: 3/28/13 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____

Date: _____ Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MF
13-3-19

POSITIVE RECALL

EFFECTIVE 30314 AUTH le

RELEASED _____ DATE _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
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| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
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| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

March-14-13 1:14:08 PM

Work Order ID: 98586

98586

Parent Item: D4785-3

D4785-3

Parent Item Name: Rib

Start Date: 3/14/13

Required Date: 3/28/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.14 NEW ISSUE VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304TS0.500W.049

Purchased

No

100

f

497.0403

1.366

1.437895

M304TS0 500W 049

**

Pl 13.3.18

Square Tubing

Location

Loc Qty

Loc Code

WA006

497.0403313

118460

10.00001534

121808

0.07

122938

257

123565

239.970316

1.438

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

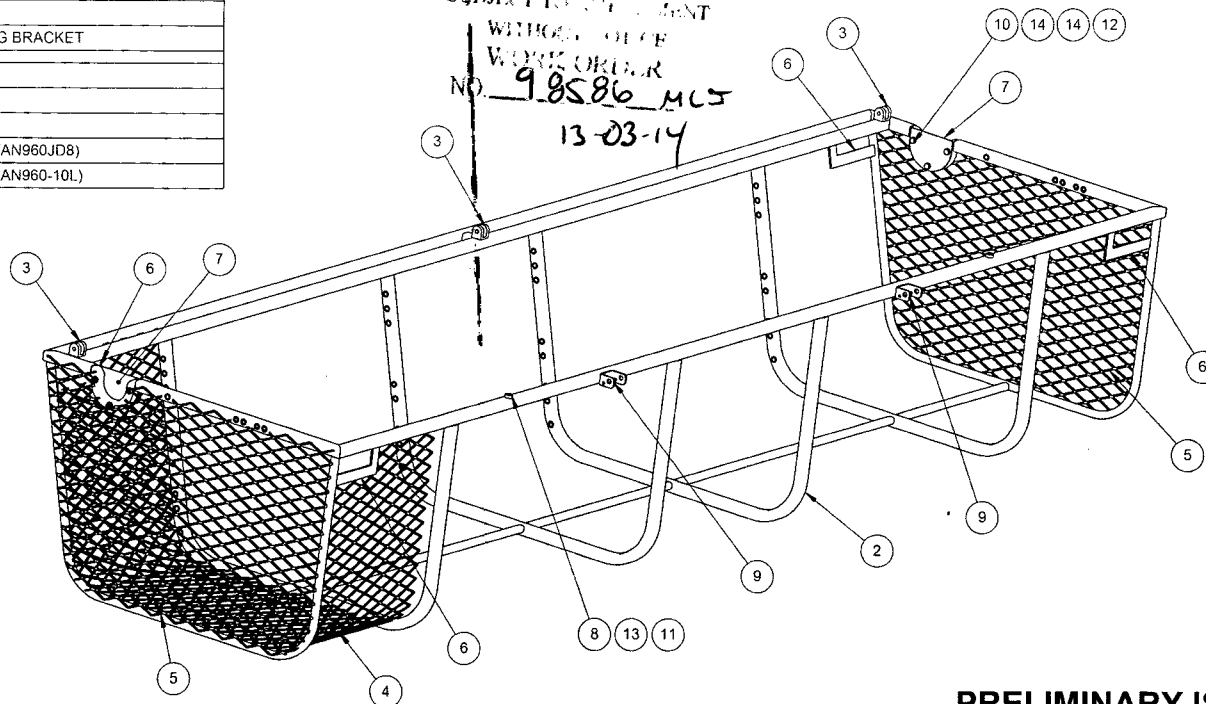
| | | | | | | | | | | | | | | | | | | |
|--|---|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

| ITEM N | QTY. .041 | PART NUMBER | DESCRIPTION |
|--------|--------------|---------------|------------------------------|
| 1 | X | D4785-041 | LONG BASKET BASE ASSY. LH/RH |
| 2 | 1 | D4785-101 | TUBULAR ASSEMBLY, LH/RH |
| 3 | 3 | D4016-1 | HINGE HALF, BASE |
| 4 | 1 | D4020-1 | MESH BASKET LONG. BASE |
| 5 | 2 | D4020-11 | END MESH. BASKET |
| 6 | 4 | D4021-1 | HANDLE PLATE |
| 7 | 2 | D4021-5 | BLANKING PLATE |
| 8 | 2 | D2931 | BUMPER |
| 9 | 2 | D2581 | MOUNTING BRACKET |
| 10 | 6 | AN3-10A | BOLT |
| 11 | 2 | MS20600AD4W3 | RIVET |
| 12 | 6 | MS21042L3 | NUT |
| 13 | 2 | NAS1149DN832J | WASHER (AN960JD8) |
| 14 | 12 | NAS1149F0332P | WASHER (AN960-10L) |



PRELIMINARY ISSUE

13.03.02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 46.23 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

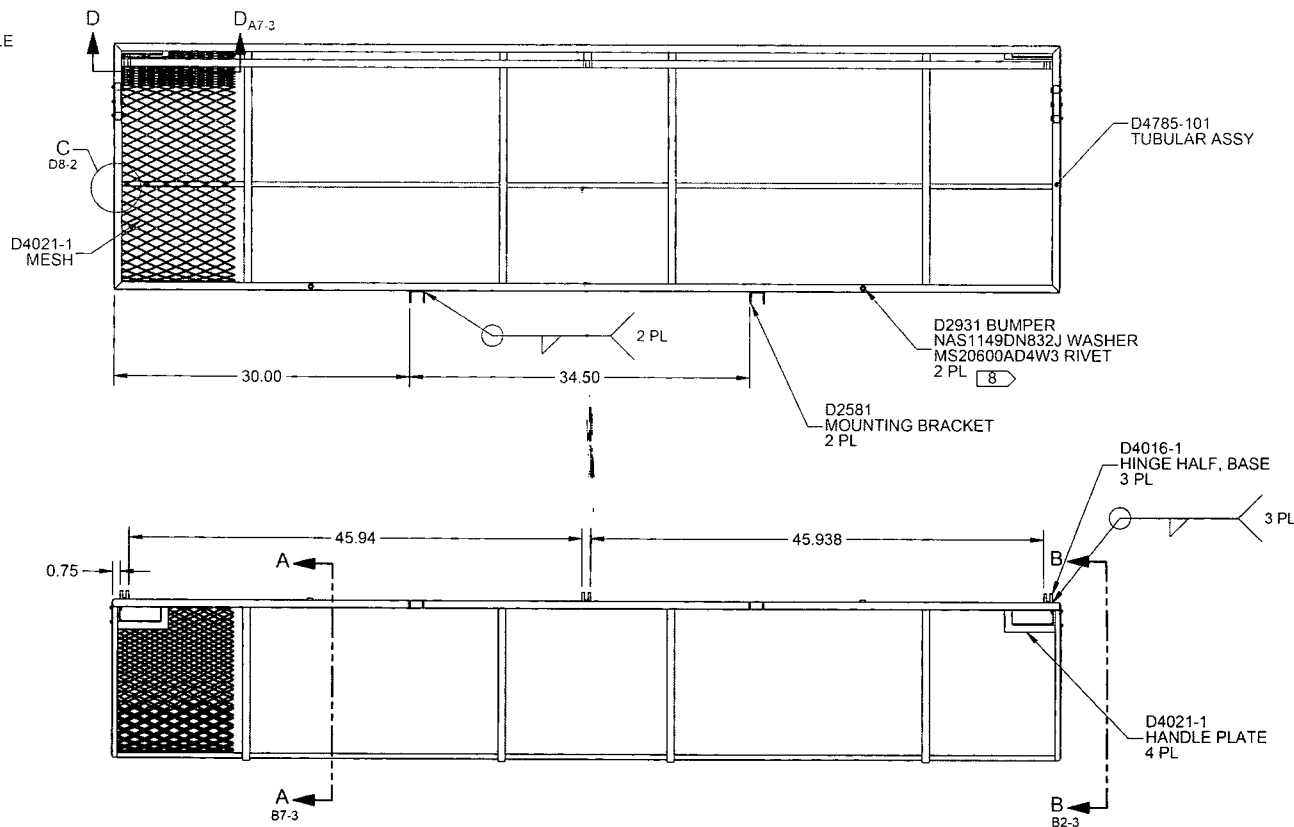
D4785-041 LONG BASKET BASE ASSY, LH/RH

| | | | |
|------------|-------------------------------------|--|--------------|
| PA2 | NEW ISSUE | RF | 13.03.02 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | | |
| DRAWN | RF | | |
| CHECKED | <input checked="" type="checkbox"/> | DART AEROSPACE LTD | REV. PA2 |
| MFG. APPR. | | HAWKESBURY, ONTARIO, CANADA | SHEET 1 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY | NTS |
| DATE | 13.03.02 | COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

92584

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

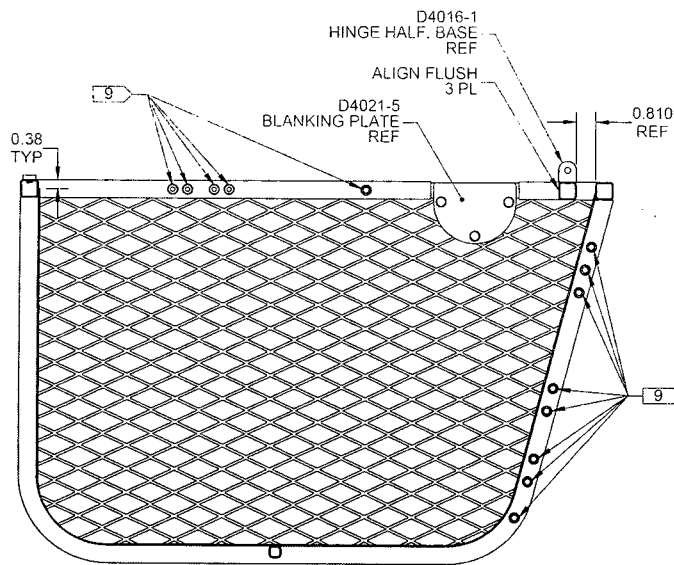
DETAIL C D7-2



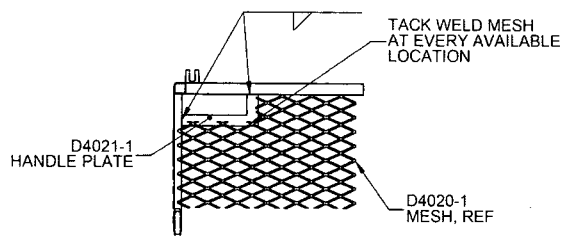
D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. PA2 |
| MFG. APPR. | | D4785 | SHEET 2 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY | NTS |
| DATE | 13.03.02 | <small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

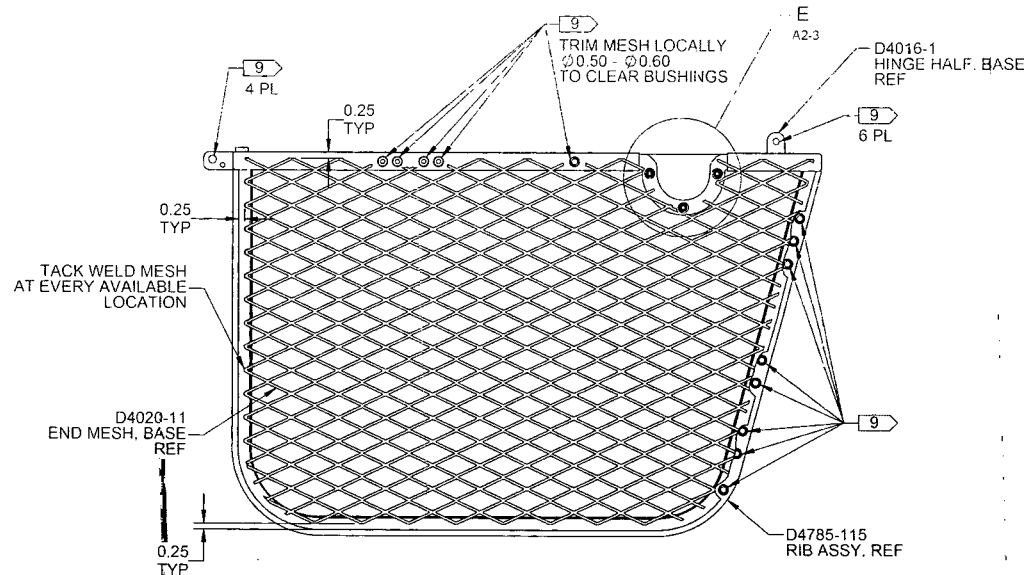
92586



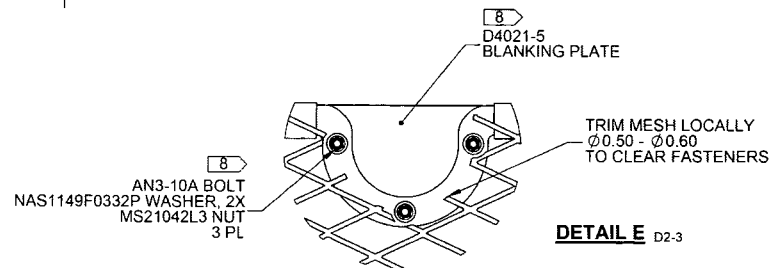
SECTION A-A B7-2



SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATES



SECTION VIEW B-B A2-2

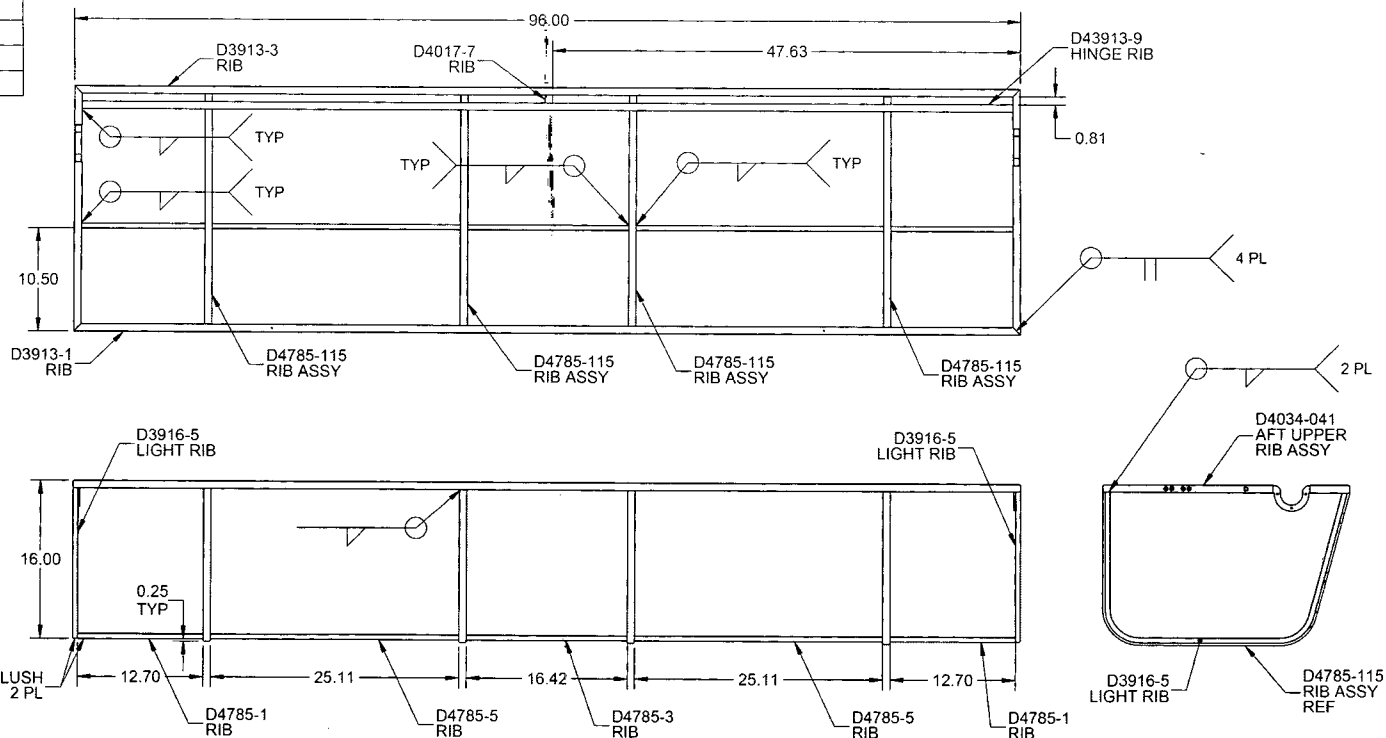


DETAIL E D2-3

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4785 | REV. PA2 |
| MFG. APPR. | | | SHEET 3 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY | NTS |
| DATE | 13.03.02 | <small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small> | |

98586

| ITEM NO. | QT -10 | PART NUMBER | DESCRIPTION |
|----------|--------|-------------|--------------------|
| 1 | X | D4785-101 | TUBULAR ASSEMBLY |
| 2 | 2 | D4785-1 | RIB |
| 3 | 4 | D4785-115 | RIB ASSEMBLY |
| 4 | 1 | D4785-3 | RIB |
| 5 | 2 | D4785-5 | RIB |
| 6 | 1 | D4017-7 | RIB |
| 7 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 8 | 1 | D4034-043 | FWD UPPER RIB ASSY |
| 9 | 2 | D3916-5 | RIB, LIGHT |
| 10 | 1 | D3913-1 | RIB |
| 11 | 1 | D3913-3 | RIB |
| 12 | 1 | D3913-9 | HINGE RIB |



NOTES:

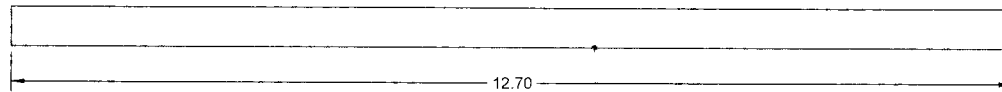
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 25.25 lbs
- 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

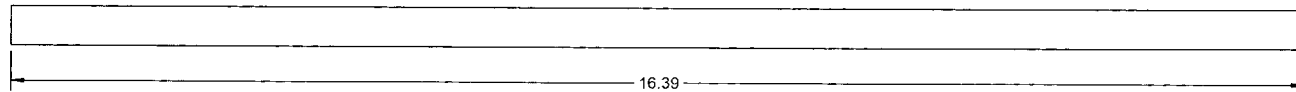
| | | | |
|------------|--------------------|--|----------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4785 | REV. PA2 |
| MFG. APPR. | | SHEET 4 OF 6 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY | |
| DATE | 13.03.02 | NTS | |

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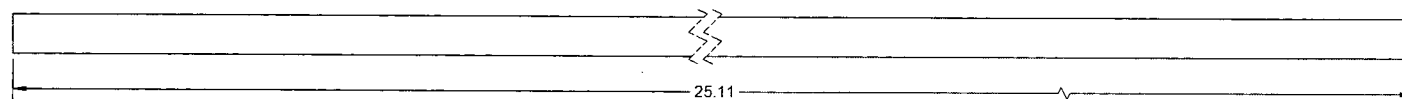
98586



D4785-1 RIB



D4785-3 RIB



D4785-5 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. PA2 |
| MFG. APPR. | | D4785 | SHEET 5 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY | NTS |
| DATE | 13.03.02 | <small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

| | | | |
|--------------------------------|--|--------------|-------------|
| DART AEROSPACE LTD | | Work Order: | B98586 |
| Description: Rib | | Part Number: | D4785-3 |
| Inspection Dwg: D4785 Rev: PAJ | | | Page 1 of 1 |

| | |
|--------------|---------|
| Measured by: | 27 |
| Date: | 13.3.19 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

Receiving Report

Date: 12/11/05

Batch No: 1123565

Supplier: CPG-6

Dart P/O: 18070

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: QAS Yes ☒ No ☐ N/A ☐
 Shipment Complete: 14 Yes ☒ No ☐ N/A ☐
 QC6 Inspection: 12/11/05 N/A ☒
 Work Order: N/A ☒

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|-------------|-------------|------------------|-------------------|-------------------|----------------|----------|
| | | | | | | |
| | | | | | | |
| | | | | | | |

Initials of receiver (if shipment OK) Level 12

Production/Admin: 12/11/05
 Date
 Received/Costing
 Initial

Location

Purchase Order Receipt Listing

Page 1 of 1

Monday, November 05, 2012 7:11:15 AM

All amounts are calculated in domestic currency.

All Vendors PO ID po18010 Receipt Dates from 11/5/2012 to 11/5/2012 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

| Purchase Order ID/ Curr Type | Line Nbr/ Insp Req | Project ID | Reference/ Description/ Cert Std | PO U/M/ Stock U/M | Required Date Required Qty | Recv Date/ Recv Emp | Recv Qty (PO U/M) | Cost Per Unit/ Recv Value | Inspected Qty/ Rejected Qty (PO U/M) | MRB Qty/ MRB Reject Qty | Book Amt |
|--|-----------------------|------------|--|----------------------|-------------------------------|------------------------|----------------------|------------------------------|--|----------------------------|------------|
| VendorID\Vendor Name VU-EAG001 Eagle Stainless | | | | | | | | | | | |
| PO18010 | 1 | | M304TS0.500W.049 f | | 11/9/2012 | 11/5/2012 | 585.0000 | \$6.25 | 0.0000 | 0 | \$3,656.25 |
| USD | No | | Square Tubing f | | 600.0000 | DESJ02 | | \$3,656.25 | 0.0000 | 0 | |
| | | | 123565 | | | | | | | | |

| | |
|--------------------------------|------------|
| Total Received Quantity: | 585.0000 |
| Total Qty to Inspect (PO U/M): | 0.0000 |
| Total Reject Quantity: | 0.0000 |
| Total Receipt Value: | \$3,656.25 |
| Total Balance Due Quantity: | 0.0000 |



EAGLE STAINLESS

Tube and Fabrication, Inc. 10 Discovery Way Franklin Industrial Park Franklin MA 02038

Tel: 800-528-8650, 508-528-8650 Fax: 800-520-1954, 508-520-1954 Email: eagle@eagletube.com Web: www.eagletube.com

Packing List

Bill Dart Aerospace, Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace, Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

PO Number: PO18010

Shipment No: 94528
Shipment Date: 10/30/12
Order Number: 111505
Order Date: 09/27/12

Customer Code: 000000001912
Phone: (613) 632-5200

Terms: Net 30 Days

Ship Via: **FED X COLL 151793240**

| Quantity | | | |
|-------------|----------------|-----------------|-----------------|
| <u>Open</u> | <u>Shipped</u> | <u>Back Ord</u> | <u>Canceled</u> |
| 600 | 585 ✓ | 0 | 15 |

Description

1912-SQ0500049T304 T304 Smls Square
Tubing .500" x .500" x .049" Wall x (60 -
117" ± .500"/-000 Lengths.)
As Drawn Temper. Chem to ASTM A269.
Certs Required. Pack to Protect.

This is NOT an Aerospace Application.....

Job
Number
111505-01

P. 12/4/12

ORIGINAL SHIPMENT
GO TO WITH SHIPMENT



EAGLE STAINLESS

Tube and Fabrication, Inc

Franklin Industrial Park 10 Discovery Way Franklin, MA 02038

Telephone: (508) 528-8650 or (800) 528-8650 Fax: (508) 520-1954 or (800) 520-1954 Website: www.eagletube.com Email: eagletube@eagletube.com

MATERIAL TEST REPORT CERTIFICATE OF CONFORMANCE

SOLD TO: Dart Aerospace, Ltd.
ADDRESS: 1270 Aberdeen Street

DATE: 10/29/2012
PURCHASE ORDER: PO18010
OUR ORDER#: 111505
PART #: NA
REVISION: NA

Hawkesbury ON K6A 1K7

HEAT #: YT4421
SOURCE: 60-45541-10-12
ITEM: .500 OD X .500 OD X .049 WALL T304/304L SMLS
Spec: ASTM A269-08/A213-09B ASME SA213-07
Temper: ANNEALED
Quantity: 585 **Units:** FT

| | |
|--------------|-------------|
| C: .028 | Ti: - |
| Si: .480 | Cb: - |
| Mn: .760 | Ta: - |
| P: .039 | Fe: balance |
| S: .004 | Cu: - |
| Ni: 8.90 | Al: - |
| Cr: 18.13 | N: - |
| Mo: - | Co: - |
| Misc Chem: - | |
| Misc Chem: - | |
| Misc Chem: - | |

Passivation Per ASTM A967: -
Yield (PSI): 44,200
Tensile (PSI): 98,600
Elong. (% IN 2"): 63
Hardness (Rockwell): B 74
Flattening: PASS
Flaring: PASS
Rev F/B: -
Flange: -
Int C/E: -
Eddy Current: PASS
Hydrostatic: PASS
Grain Size:

Notes: -
Notes: -
Notes: -
Comments:

DAS
14
2.5 12/1/05

Conforms to all drawing and/or specification requirements. To the best of our knowledge the material is mercury free, and compliant with Directive 2011/65/EC and 2006/122/ECOF regarding the Restriction of Hazardous Substances (RoHS). Reports governing this material are on file.

Bernie Pearson

EAGLE STAINLESS TUBE AND FABRICATION INC.
Bernie Pearson
Quality Assurance Manager

BP

Int.

10/29/2012

Date



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18010**

Purchase Order Date 9/26/12

PO Print Date 9/26/12

Page Number 1 of 1

Order From :

VU-EAG001

EAGLE STAINLESS
10 DISCOVERY WAY
FRANKLIN, MA
US

Contact Name

Vendor Phone

800 528 8650

Vendor Fax

800 520 1954

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
123565

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|------------------------|----------------------|-----------------------------|-----------------|------------|-------------------|
| 1 | M304TS0.500W.049 | Square Tubing | 11/09/12 Yes | 600.00 | Fedex Freight C | \$6.2500 | \$3,750.00 |

Special Inst: MATERIAL: AISI 304/316 SEAMLESS
STAINLESS STEEL SQUARE TUBING
ASTM A554 MILL FINISH OR ASTM
A269 MILL FINISH

PO Total:

\$3,750.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Change Nbr: 1

Change Date: 9/26/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO